

Date: Friday, 8/10/2007 11:49:50 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 33873		
Estimate Number	: 12984		
P.O. Number	:	Part Number	: D36201
This Issue	: 8/10/2007 S.O. No. :	Drawing Number	: D3620 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	: <u>Jul 07.08.10</u>	Due Date	: 8/17/2007
Checked & Approved By	:	Qty:	39 Um: Each
Comment	: Est A 07.08.09 new issue EC verified by: JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0625	303 Round Bar 0.625"
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Comment: Qty.: 0.1943 f(s)/Unit Total : 5.8275 f(s) 10.58

Material: Ø0.625 AISI 303 SS Rod (M303R0625)

Batch M13838 15267

RP 07/08/13

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA703

Deburr and tumble

RP

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 07/08/13

(39)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RP 07/08/13

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SL 110

7/8/14

(39x)

SP

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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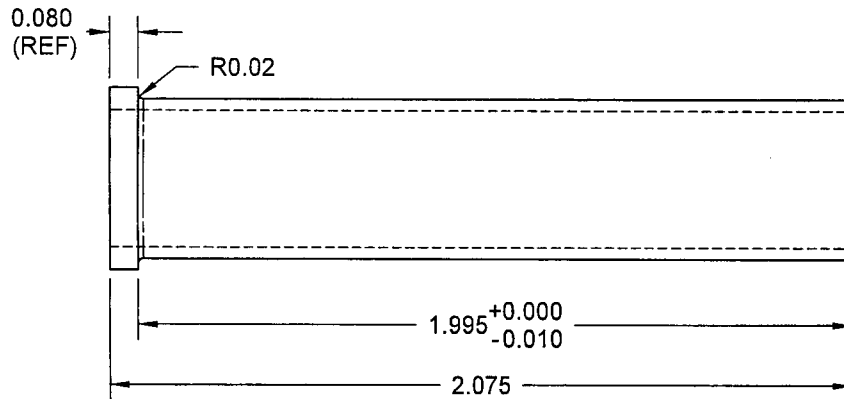
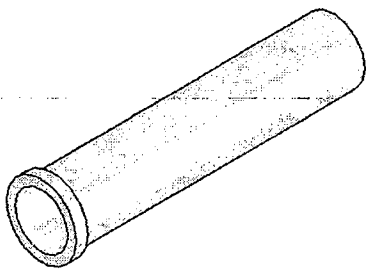
Comment: FINAL INSPECTION/W/O RELEASE

07.08.14

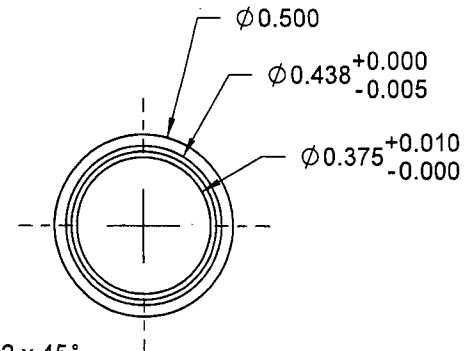
Job Completion



C207/08/14



CHAMFER 0.02 x 45°  
(ALL AROUND INSIDE)



# **D3620-1 BUSHING**

**RELEASED**  
07.08.07

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING  
(REF DART SPEC M304TR) OR  
AISI 303 STAINLESS STEEL ROUND BAR  
(REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3620-1" USING FINE POINT  
PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

A	NEW ISSUE	CB	07.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	C.B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	C.B		
CHECKED	CE	DRAWING NO.	REV. A
MFG. APPR.	E	D3620	SHEET 1 OF 1
APPROVED	#	TITLE	SCALE
DE APPR.	#	BUSHING	2:1
DATE	07.07.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: <b>33873</b>
Description: Crosstube Assembly		Part Number: <b>D3620-1</b>
Inspection Dwg:	Rev: <b>A</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.075	+/- .010	2.076				
	1.995	+/- .010	1.994				
	0.08	+/- .030	.082				
	0.02	+/- .030	.015				
	.500	+/- .010	.500				
	.438	-.005	.435				
	.375	+ .010	.375				
SIDE B							

Measured by: <b>RQ</b>	Audited by: <b>SA</b>	Prototype Approval:	N/A
Date: <b>07/08/13</b>	Date: <b>07.08.13</b>	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM
			Approved